

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026776**Date Inspected:** 22-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Chris Concha**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Traveler Mechanical Assemblies

This QA Inspector randomly observed WMI qualified welder Mr. Daniel Grayum (WID # 3049) performing fitting, tack welding and welding activities on mechanical console box frames for the Maintenance Travelers throughout the shift.

RPI Coating (Blast and Paint)

This QA Inspector performed random shop observations and observed that RPI Coating is on site to continue abrasive blast and prime coat application on the Elevating Platforms and Bike Path Traveler Assemblies. QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI is going to sweep/spot blast and apply the Sherwin Williams Zinc Clad II prime coat to the today. Later in the morning this QA Inspector randomly observed that RPI personnel performing sweep/spot blasting activities on one (1) Elevation Platform and Bike Path Beams A1 and A5. After sweep blasting was completed, QA Inspector then observed Mr. Keen performing random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Keen utilizing a Testex Press-O-Film and a micrometer to perform the testing. During observation, this QA Inspector observed that the readings appeared to be 3.6 mils. QA Inspector then observed Mr. Keen perform a test for soluble salts on the previously blasted base metal surface. Testing observed by QA Inspector appears to be in compliance with the contract requirements.

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Later in the shift, this QA Inspector randomly observed RPI Coating performing what appeared to be primer application activities within what appeared to be within an 8 hour time frame from the above mentioned sweep blasting activities. Environmental readings taken by RPI at the time of the coating application are as follows Air Temperature 45/78 F, Relative Humidity 71/49%, Wet Bulb Temperature 42/59 F, Dew point 37/47 F and Surface Temperature 44/70 F.

This QA Inspector performed measurement on dry coating thickness with Type 2 (magnetic gage), DFT's thickness reading of the prime coated surface coated on 11-21-11 are an average of three (3) thickness readings as follows 5.2 mils, 3.7 mils, 5.2 mils, 3.9 mils, 4.4 mils, and 4.2 mils. QA Inspector also, observed Mr. Keen documenting daily activities on RPI Coating QC Daily Inspection Report.

SAS WB Traveler

This QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up welding not completed on this date.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer